

Work Order ID 59401

Thursday, June 03, 2010 12:41:37 PM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 6/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

10-6-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *111679* 0.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

(1) PL 10.06.11

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

(1) PD 10.06.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action . Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

Work Order ID 59401


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Item ID: D3913-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Long Basket Base Assembly, 350
Start Date: 6/3/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 6/14/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Solbelu		(40)			
---	---	--------------	--	---------	--	------	--	--	--

130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1114841 1- Plug holes and mask only interior of hinge (3) prior to powder coat	0.00 0.00		=> 10/06/15		1	2		
---	---	--------------	--	-------------	--	---	---	--	--

1ST COAT:
START TIME: 8:30 AM
OVEN TEMPERATURE: 400°C
FINISH TIME: 9:00 AM
***** 2nd coat if necessary*****
2ND COAT:
START TIME: 9:30 AM
OVEN TEMPERATURE: 400°C
FINISH TIME: 10:00 AM

W/O:		WORK ORDER CHANGES					
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Required Date: 6/14/2010 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

① BR 10-6-15

150

Assemble as per dwg

0.00

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

JS 10/06/15 ②

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

E 6/6/16

①

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Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Identify as per dwg & Stock Location: *6-A*

0.00

Memo

0.00

Packaging

*w/p 59399**ES 10/06/16 @*

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*10/06/17**MF 10.6-16*

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Picklist Print

Thursday, June 03, 2010 12:41:42 PM

Work Order ID: 59401

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 6/3/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2581
Mounting Bracket

Location	Loc Qty	Loc Code
ST	22	
59121	22	
WA	49	
46086	2	
51745	2	
57185	1	
58301	5	
58687	18	
59265	21	

Manufactured No

100 Each 3.0000

1 1

✓ D3913-1
Rib

Location	Loc Qty	Loc Code
WA	3	
58741	3	

Manufactured No

100 Each 10.0000

1 1

✓ D3913-15
Wide Handle Plate

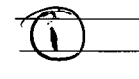
Location	Loc Qty	Loc Code
WA	10	
58125	7	
58586	3	



Pl 10.06.07

Pl 10.06.07

Pl 10.06.07



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Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D3913-3
Rib

Manufactured No

Location	Loc Qty	Loc Code
WA	4	
58578	1	
58742	3	



Pl 10.06.07

✓ D3913-7
Rib

Manufactured No

Location	Loc Qty	Loc Code
WA	6	
58690	6	



B58690 → (2)

✓ D3913-9
Hinge Rib

Manufactured No

Location	Loc Qty	Loc Code
WA	4	
58582	1	
59293	3	



B59293 → (1)

✓ D3916-041
Rib Assembly

Manufactured No

Location	Loc Qty	Loc Code
WA	6	
58688	6	



Pl 10.06.07

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Page 2

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chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 6/3/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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✓ D3916-5
Light Rib

Location Loc Qty Loc Code

WA 8
57023 2
58678 6

100 Each 15.0000 3



B59333 → (3)

✓ D4016-1
Hinge Half, Base

Manufactured No

Location Loc Qty Loc Code

WA 15
58657 6
58745 9

100 Each 6.0000 1



(3)

* D4017-7
Rib

Manufactured No

Location Loc Qty Loc Code

WA 6
58133 1
58521 2
58929 3

100 Each 6.0000 2



(1)

✓ D4017-9
Rib

Manufactured No

Location Loc Qty Loc Code

WA 6
58689 6



(2)

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Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC


IPP Rev:B

Start Date: 6/3/2010

Required Date: 6/14/2010


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4020-1  Mesh (350 Basket Long, Base)		Manufactured	No			100	Each	2.0000	1	1		6/10/09	


Location	Loc Qty	Loc Code
WA	2	
59025	1	
59092	1	

359554 → ①

✓ D4020-11  End Mesh, Basket		Manufactured	No			100	Each	10.0000	2	2		6/10/09	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	---------	--

Location	Loc Qty	Loc Code
WA	10	
56990	1	
58136	3	
58931	6	

②

✓ D4021-1  Handle Plate		Manufactured	No			100	Each	16.0000	3	3		6/10/07	
---	--	--------------	----	--	--	-----	------	---------	---	---	--	---------	--

Location	Loc Qty	Loc Code
ST109	5	
57086	5	
WA	11	
58525	2	
58746	9	

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Long Basket Base Assembly, 350

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 6/3/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4034-041
Aft Upper Rib Assembly

Location Loc Qty Loc Code

WA 4
58141 1
58696 3

100 Each 3.0000

* D4034-043
Fwd Upper Rib Assembly

Manufactured No

Location Loc Qty Loc Code

WA 3
58697 3

150 Each 38.0000

AN3-10A
Bolt

Purchased No

Location Loc Qty Loc Code

ST351 38
114330 38

150 Each 0.0000

* AN960JD8
Washer

NAS1149DN832 Purchased No

7 M114740 (2x)

1 1
Pl 10.06.07

1 1
Pl 10.06.07

358142 → 1
6 6
E 5/10/06/16

6 6
E 5/10/06/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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chg qty's DD 10.04.12 verified by:EC




IPP Rev:B

Start Date: 6/3/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2931  Bumper		Manufactured	No			150	Each	848.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				848					
				46064				848					
D4021-5  Blanking Plate		Manufactured	No			150	Each	15.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST109				3					
				58140				3					
				ST111				12					
				59096				12					
MS20600-AD4W3  Cherry Rivets		Purchased	No			150	Each	1,775.000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST321				1775					
				106375				3					
				107939				822					
				111636				950					

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chg qty's DD 10.04.12 verified by:EC


IPP Rev:B

Start Date: 6/3/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			150	Each	3,520.000	6	6			
													
Nut													

Location	Loc Qty	Loc Code
ST300	3520	
113537	20	
114523	1000	
114718	500	
114784	2000	

NAS1149F0332P

Purchased

No

150

Each

779.0000

12

12



WASHER

Location	Loc Qty	Loc Code
ST275	779	
18057	779	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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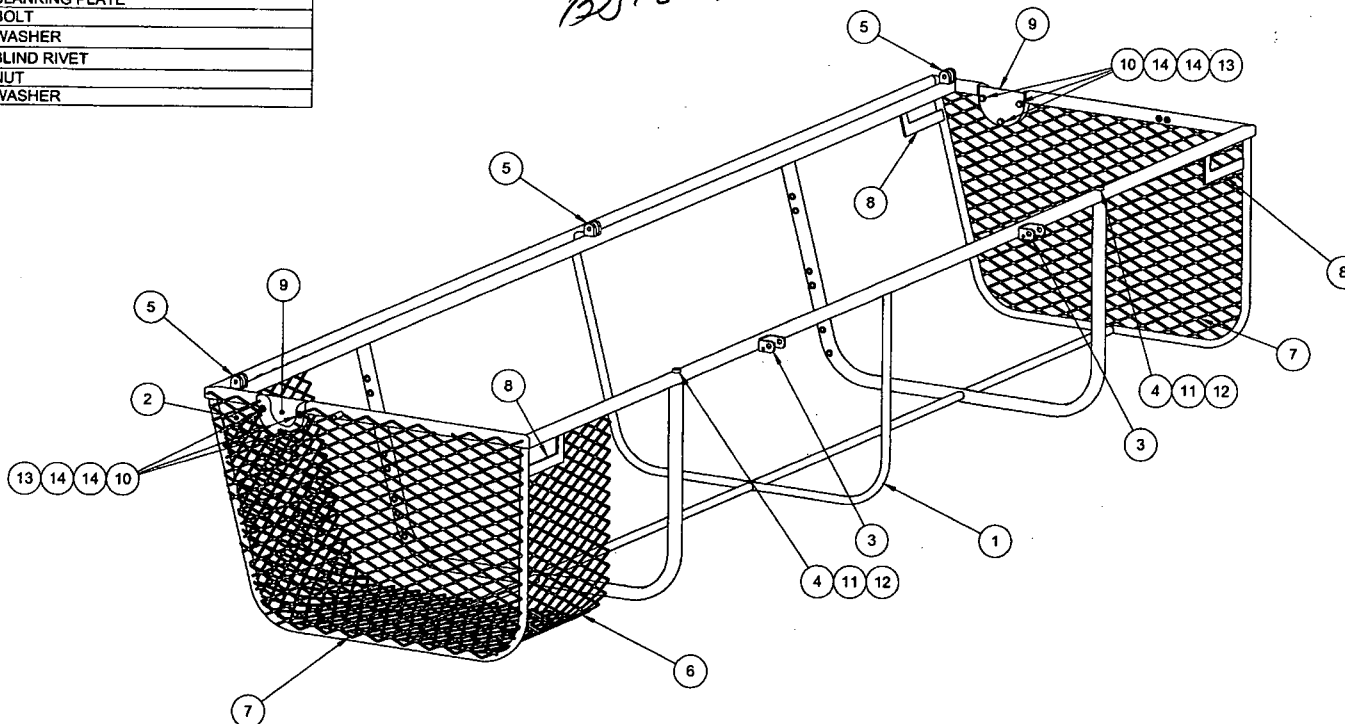
NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59402
BS10-4-03

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A		NEW ISSUE		JPH	10.03.16
REV.		DESCRIPTION		BY	DATE
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		JPH			
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.				DRAWING NO. REV. A	
DATE		10.03.16		D3913 SHEET 1 OF 6	
				TITLE LONG BASKET BASE ASSY (350) NT	
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D A7-3
D
D8-2 C
D4020-1
MESH

D3913-101
TUBULAR ASSY

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL [8]

D2581
MOUNTING BRACKET
2 PL

D4016-1
HINGE HALF, BASE
3 PL

D4021-1
HANDLE PLATE
2 PL

D4021-1
HANDLE PLATE

C7-3 A

C3-3 B

D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

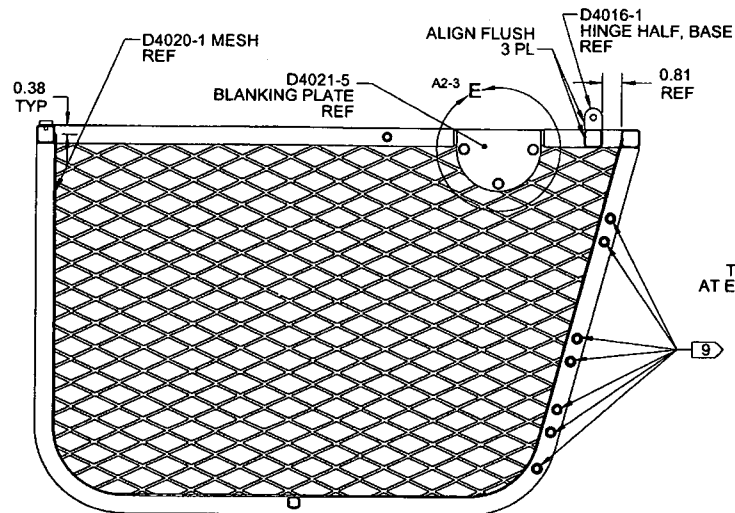
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

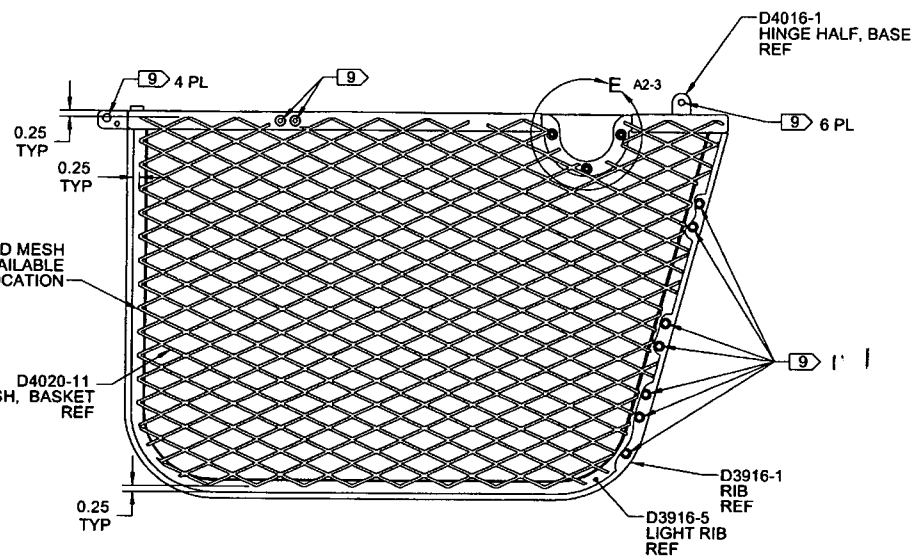
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

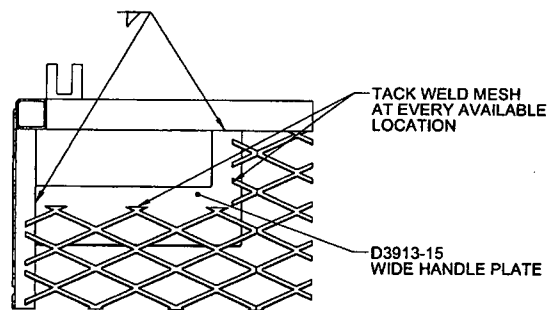
NOTE: Date & initial all entries



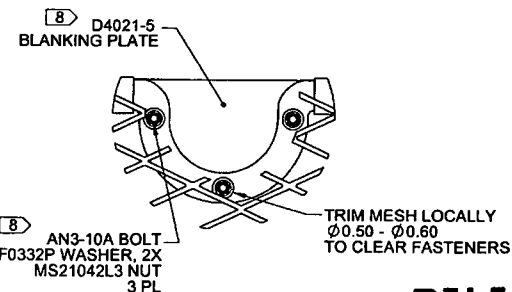
SECTION A-A A5-2



VIEW B-B A2-2







SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D2-3
D6-3

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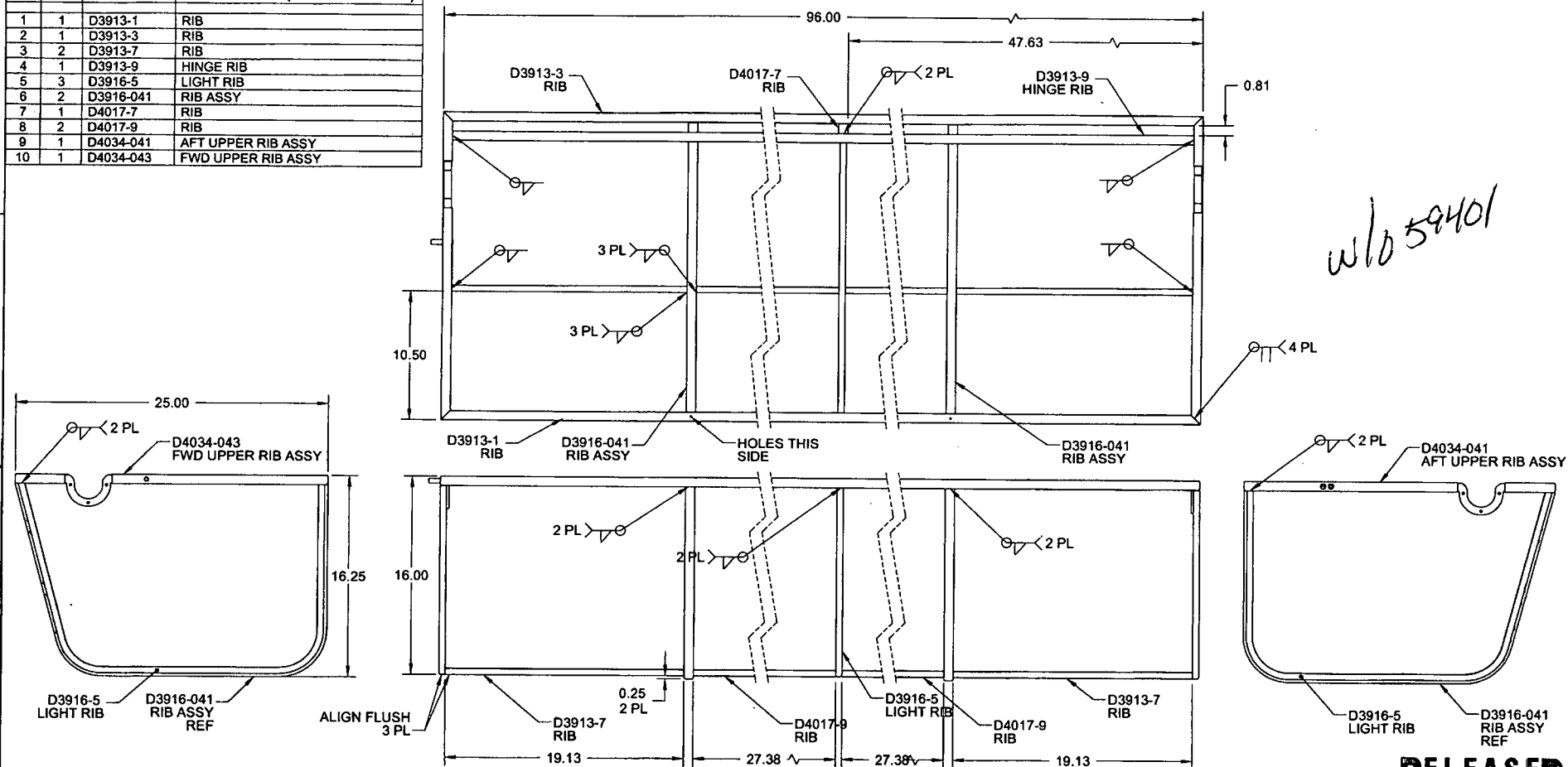
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

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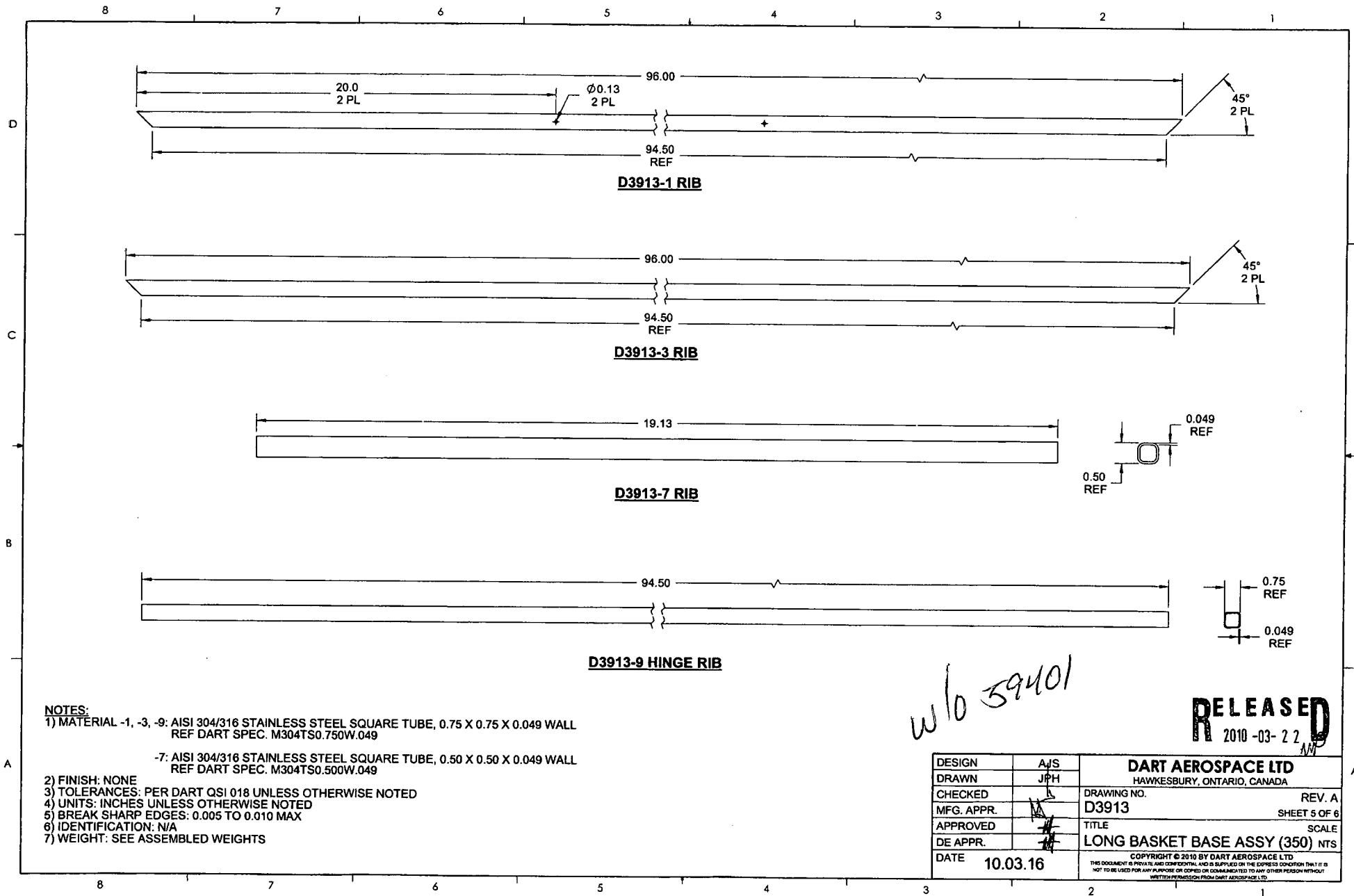
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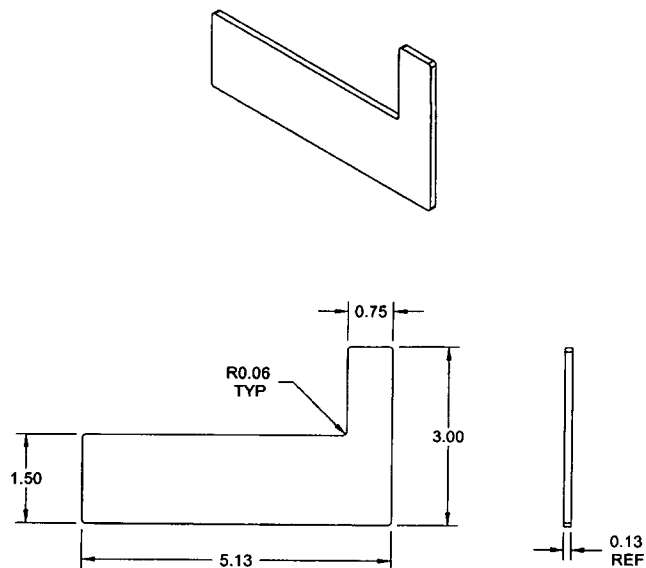
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NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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JMD

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